

What is claimed is:

- 5 1. A door for refrigerator which is composed of a door panel made of metal, an inner panel combined with the door panel, a door cap fitting into the door panel and the inner panel in an upper portion, and a handle fitting into the door panel and the inner panel in a bottom portion, the door for refrigerator having a heat insulating foam material injected inside, the door for refrigerator comprising:
- 10 draw forming provided at a position near to an edge of at least either side of the door panel.
- 15 2. The door for refrigerator of claim 1, wherein the draw forming is provided at the position of approximately ten percent (10%) of a full width of the door panel away from the edge.
- 20 3. The door for refrigerator of claim 1, wherein the draw forming is provided in such a manner as to push the door panel outwards to form a convexity at a center portion of the door panel.
- 25 4. The door for refrigerator of claim 1, wherein the door panel has a two-tone color, and wherein the draw forming is provided on a boundary

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of colors.

5. A door for refrigerator which is composed of a door panel made of metal, an inner panel combined with the door panel, a door cap fitting into the door panel and the inner panel in an upper portion, and a handle fitting into the door panel and the inner panel in a bottom portion, the door for refrigerator having a heat insulating foam material injected inside, the door for refrigerator comprising:

draw forming provided at a given position of the door panel;

wherein the door panel has a two-tone color, and

wherein the draw forming is provided on a boundary of colors.

6. The door for refrigerator of claims 4 or 5, further comprising:

a gradation portion provided in the two-tone color; wherein the draw forming is provided on the gradation portion.

7. The door for refrigerator of claim 4 or 5, wherein the boundary of the colors is provided close to a center portion of the draw forming.

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8. A method of producing a door for refrigerator which is composed of a door panel made of metal, an inner panel combined with the door panel, a door cap fitting into the door panel and the inner panel in an upper portion, and a handle fitting into the door panel and the inner panel in a bottom portion, the door for refrigerator having a heat insulating foam material injected inside, the method of producing the door for refrigerator comprising:

providing draw forming at a position near to an edge of at least either side of the door panel.

9. A method of producing a door for refrigerator which is composed of a door panel made of metal, an inner panel combined with the door panel, a door cap fitting into the door panel and the inner panel in an upper portion, and a handle fitting into the door panel and the inner panel in a bottom portion, the door for refrigerator having a heat insulating foam material injected inside, the method of producing the door for refrigerator comprising:

providing draw forming at a given position of the door panel,

coloring the door panel in two-tone color, and

providing the draw forming on a boundary of colors.

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Embodiment 1.

Fig. 1 and Fig. 2 are diagrams illustrating a door for refrigerator according to a first embodiment of the present invention. Fig. 1 shows a front view of the door for refrigerator. Fig. 2 shows a Z-Z sectional view of the door for refrigerator of Fig. 1.

Referring to the figures, a door 1 is composed of the combination of a door panel 3, which is one of the components of a front design view of the door 1, and an inner plate 2, which is provided on an inner side of the door panel 3, and a door cap 4 fitting into the combination on an upper portion and a handle 5 fitting into the combination on a bottom portion. The door 1 is provided inside with a heat insulating form material 6.

The door panel 3 is painted in two-tone color. The color of the shaded portions on the door panel 3 of Fig. 1 is different from the color of the other portions. The two-tone color may be of tones of a color with a touch of relaxation such as a combination of deep blue and light blue or of deep gray and white gray, for example. Furthermore, draw forming is provided on the boundaries of the two-tone color on both sides of the door panel 3 by press working in such a manner as to push the center portion of the door panel 3 outwards to form a convexity.

Then, the draw forming is provided at a position of approximately ten percent (10%) of a full width of the door panel 3 away from an edge of the door panel 3 on each side.

5            Fig. 3 is a graph illustrating a relation between a draw forming position B and a maximum amount of displacement of the door panel 3 when the draw forming is provided on both sides of the door panel 3. Fig. 4 is a graph illustrating a relation between a draw forming  
10           position B and a maximum amount of displacement of the door panel 3 when the draw forming is provided on either side of the door panel 3.

As illustrated in the graphs of Fig. 3 and Fig. 4, the door panel 3 gets most reinforced with a least amount  
15           of displacement when the draw forming is provided at a position of approximately ten percent (10%) of the full width of the door panel 3 away from a side edge of the door panel 3. For that reason, the additional sheet metal part needed for the conventional door for refrigerator for  
20           the purpose of keeping the door panel 3 from getting uneven on the surface is allowed to be eliminated.

In addition to that, the draw forming is thus provided in such a manner as to push the center portion of the door panel 3 outwards to form a convexity. For that  
25           reason, it is possible to secure enough thickness for an

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efficient heat insulation, thereby achieving less thermal leakage through the door 1.

Furthermore, with a standard module (500-800 in width, 1500-1800 in height) of refrigerator, if the door is designed in such a manner as to give an impression of a frame on the surface of the door on each side, the most effective ratio for the width of the frame (the ratio in which the frame is recognized most effectively) is 10% or less compared to a full width of a door in a front view. For that reason, by placing the draw forming at this most effective position, the design of the door can give the impression that the frame is on the surface of the door on each sided without adding extra separate parts of injection or the like.

Thus, as stated above, according to this embodiment, the door for refrigerator wears an accent in color on both sides of the door panel 3. Alternatively, the accent in color may be provided on either side of the door panel 3. Still alternatively, the draw forming may be provided in any position on the door panel 3 as long as the design of the door is sophisticated enough. For example, the draw forming may be provided at a center portion of the door panel 3 or at any upper and bottom portions of the door panel 3.

It is a positive effect of the door for refrigerator

of this embodiment with the draw forming provided at the position near to the edge of at least either side of the door panel that the door panel is allowed to be reinforced. For that reason, the reinforcing sheet metal needed for

5 keeping the door panel from getting uneven on the surface is eliminated. This allows the door for refrigerator to be provided at a lower production cost.

It is another positive effect of the door for refrigerator of this embodiment with the draw forming

10 provided at the position of approximately 10% of the full width of the door panel away from a side edge of the door panel that the door panel is allowed to be most reinforced.

It is still another positive effect of the door for refrigerator of this embodiment with the draw forming

15 provided in such a manner as to push the center portion of the door panel outwards to form a convexity that the heat insulating wall is allowed to secure enough thickness for producing an energy-saving door for refrigerator.

It is still another positive effect of the door for refrigerator of this embodiment with the draw forming

20 provided in the two-tone door panel that the door is allowed to wear an accent in color on both sides or either side thereof. In addition to that, the door for refrigerator of this embodiment is allowed to be provided

25 in the sophisticated design which is associated with a

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frame without adding extra separate parts and at a lower production cost.

It is still another positive effect of the door for refrigerator of this embodiment with the draw forming

5 provided in any given portion of the door panel, with the door panel painted in two-tone color, and with the draw forming provided on the boundary of the two-tone color that the door panel is allowed to be reinforced, thereby eliminating the reinforcing sheet metal for keeping the  
10 door panel from getting uneven on the surface. In addition to that, the door is allowed to wear an accent in color. For that reason, the door for refrigerator of this embodiment is allowed to be sophisticated in design and provided at a lower production cost.

15 According to a method of producing the door for refrigerator of the present invention, the draw forming may be provided at the position near to the edge of at least either side of the door panel. For that reason, the door panel is allowed to be reinforced, thereby  
20 eliminating the reinforcing sheet metal for keeping the door panel from getting uneven on the surface. Consequently, the door for refrigerator is allowed to be provided at a lower production cost.

25 According to another method of producing the door for refrigerator of the present invention, the draw

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forming may be provided on a given portion of the door panel, the door panel may be painted in two-tone color, and the draw forming may be provided on the boundary of the two-tone color. For that reason, the door panel is  
5 allowed to be reinforced, thereby eliminating the reinforcing sheet metal for keeping the door panel from getting uneven on the surface. In addition to that, the door is allowed to wear an accent in color. This allows the door for refrigerator to be sophisticated in design  
10 and provided at a lower production cost.

#### Embodiment 2.

Fig. 5 is a sectional view of a door for refrigerator according to a second embodiment. Referring  
15 to the figure, a reference numeral 7 denotes a gradation portion having a series of changes of hues. A reference numeral 8 denotes a draw forming portion which is provided on the gradation portion 7. The other portions of the door for refrigerator of Fig. 5 are the same as those discussed  
20 with reference to the door for refrigerator of Fig. 2.

In order to absorb displacement caused by press working, the gradation portion 7 is provided on the boundary of the two-tone color, and the draw forming portion 8 is provided on the gradation portion 7.

25 It is a positive effect of the door for refrigerator

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of this embodiment with the gradation portion provided between the colors of the two-tone door panel, and with the draw forming portion provided on the gradation portion that the displacement caused by the draw forming press working is prevented.

### Embodiment 3.

Fig. 6 is a sectional view of a door for refrigerator according to a third embodiment. Referring to the figure, a reference numeral 9 denotes a boundary of two-tone color. The other portions of the door for refrigerator of Fig. 6 are the same as those discussed with reference to the door for refrigerator of Fig. 2 or Fig. 5.

The boundary of two-tone color 9 is placed in a center portion of the draw forming in consideration of displacement caused by press working, thereby allowing the press working to be done easily.

It is a positive effect of the door for refrigerator of this embodiment with the boundary of two-tone color placed at the center portion of the draw forming that the press working is allowed to be done easily.

The invention being thus described, it will be obvious that the same may be varied in many ways. Such

variations are not to be regarded as a departure from the spirit and scope of the invention, and all such modifications as would be obvious to one skilled in the art are intended to be included within the scope of the following claims.

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